

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009303**Date Inspected:** 18-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen fu you**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

SEGEMENT

SMAW welding of weld joint 4F-209 located on PCMK SSD11A-PP63 of 8AW welder is identified as 067904. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

BAY#14

FCAW welding of weld joint 1F-063 located on PCMK SP769-001 of 9BW welder is identified as 045218.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2131.

FCAW welding of weld joint 3G-130 located on PCMK SP10-PP74 of 9BW welder is identified as 0201215. ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

FCAW welding of weld joint 3F-120 located on PCMK DP151-001 of 9CW welder is identified as 062708.ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the

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WPS-B-T-2133.

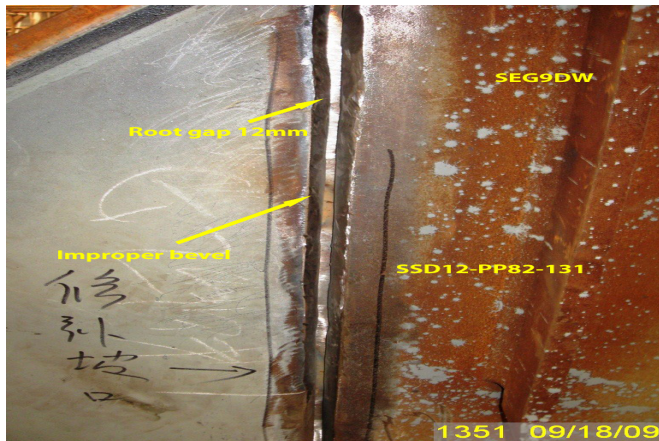
FCAW welding of weld joint 1G-009 located on PCMK SSD11-PP75 of 9BW welder is identified as 066401. ZPMC QC is identified as Mr.Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2a.

During in process inspection it is found that on going work on WR-7456 , the WR says use ceramic backing bar after welding do grinding on the other side and make flush grind with base metal But in actual ZPMC did gouge the other side and carryout grinding.

Weld joint fit up of following weld joint not comply with the WPS-B-T-2233-B-U2-F.

Weld joint no is SSD12-PP82-131 of 9DW. Root gap 12mm and bevel not made properly.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Item	Description	WBS	Dwg No.	Status
1				
2				

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
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Reviewed By: Clifford, William

QA Reviewer